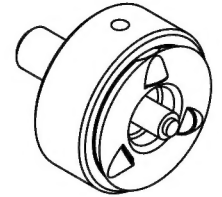
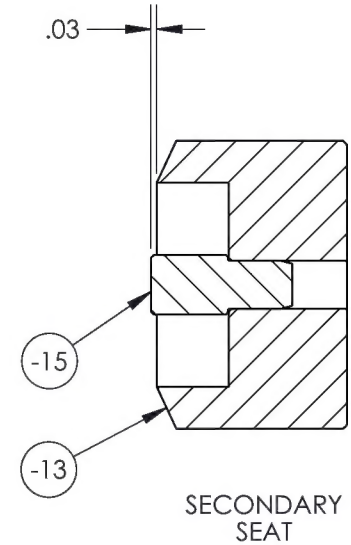
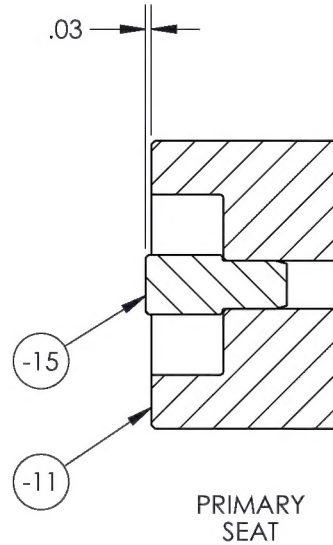
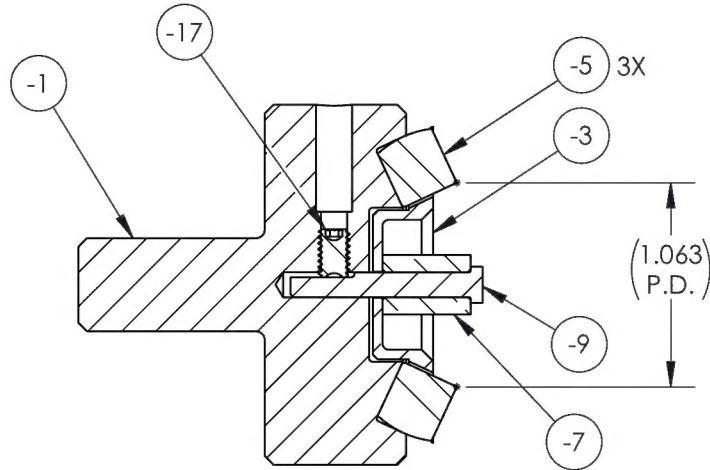


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/6/2017	DPD	JAG



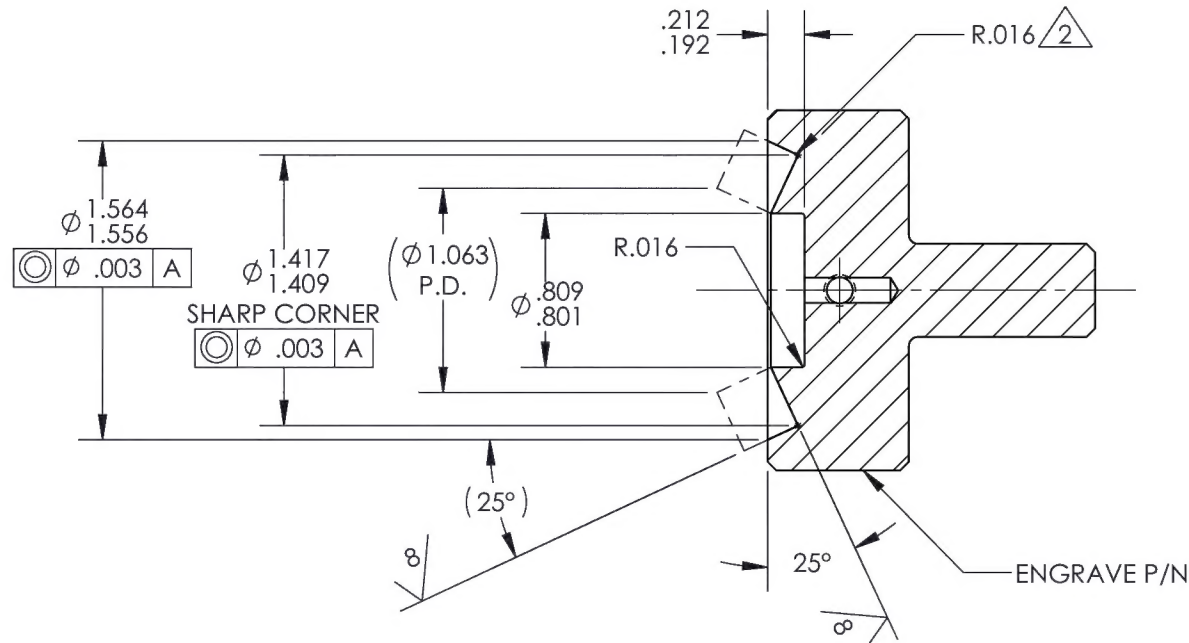
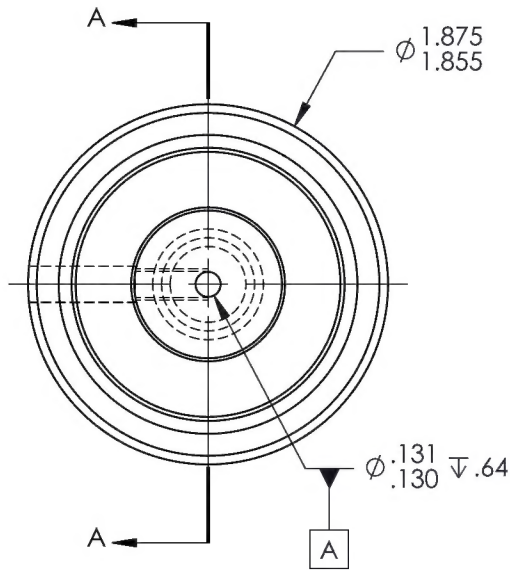
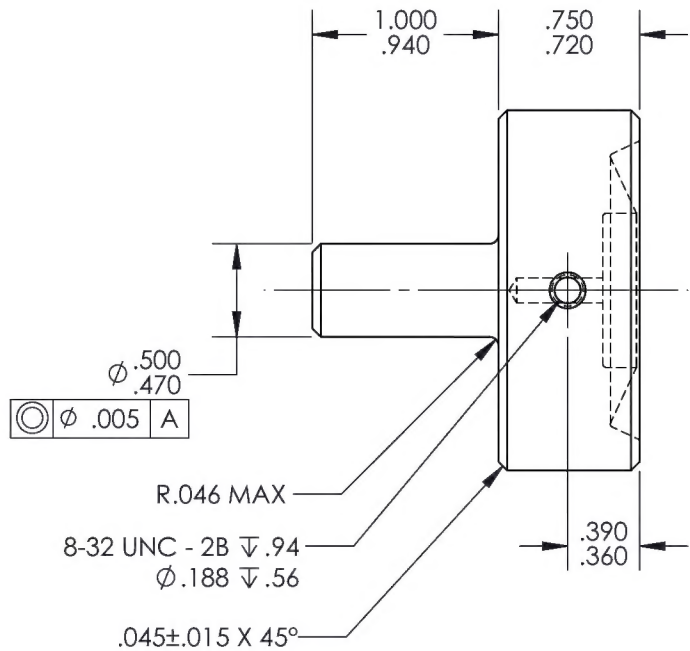
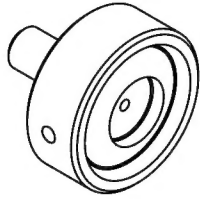
NOTE:
USED FOR BEARING 412-010-182-103.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ROLLER FIXTURE	0-1 DRILL ROD		2
			-3	1	RETAINER	BRONZE		3
			-5	3	ROLLER	STEEL	Ø.031, CLASS ZZ, MINUS (GAUGE PIN MSC #89031009) MODIFIED	4
			-7	1	GUIDE	BRONZE		5
			-9	1	PIN	STEEL	Ø.129 X 2-1/2 (MCMaster-CARR #98378A909) MODIFIED	6
			-11	1	PRIMARY SEAT	4140/4142		7
			-13	1	SECONDARY SEAT	4140/4142		8
			-15	2	LOCATING PIN	1018/1020 CR		9
		B/O	-17	1	SOCKET HEAD SET SCREW	S.S.	#8-32 X 1/4 (MCMaster-CARR #97705A406)	1

DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241	REV 1
MAT'L HEAT TREAT FINISH SPEC DRAWN BY: DD 04/05/2017 CHECKED: SM 04/05/2017 OPPTS APPR: AA 04/05/2017 QA APPR: JL 04/05/2017 APPROVED: JAG 04/06/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SCALE 1:1	DATE 4/5/2017
SHEET 1 OF 9	

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APPROVED				



SECTION A-A

- NOTES:
1. BREAK ALL SHARP CORNERS .015-.030
 2. DIMENSION TO BOTTOM OF R.016=.153; DIMENSION TO SHARP CORNER=.158.
 3. DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.



TITLE
DRILL PRESS SWAGING TOOL

DWG NO. RBST4241-1

REV
1

MAT'L 0-1 DRILL ROD

HEAT TREAT RC 55-60

FINISH ZINC PLATE

SPEC QMSI-6.2.2, B.O. REV D

DRAWN BY: DD 04/05/2017

CHECKED: SM 04/05/2017

OPPS APPR: AA 04/05/2017

QA APPR: JL 04/05/2017

APPROVED: JAG 04/06/2017

SCALE 1:1

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± 5°

.X ± .1 SURFACES = 125/

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

USED ON MODEL

DATE 4/5/2017

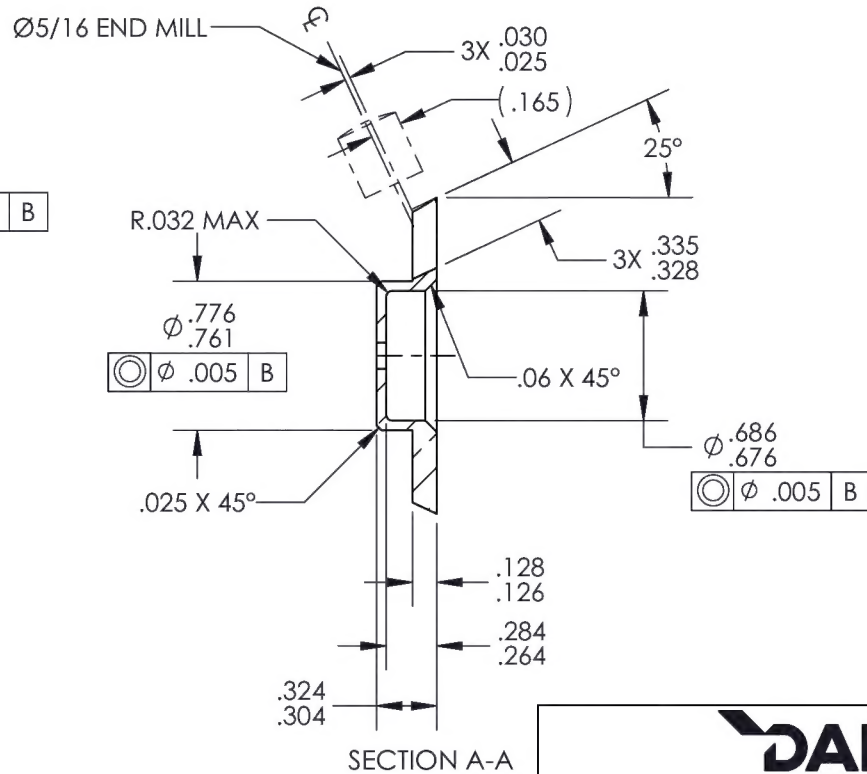
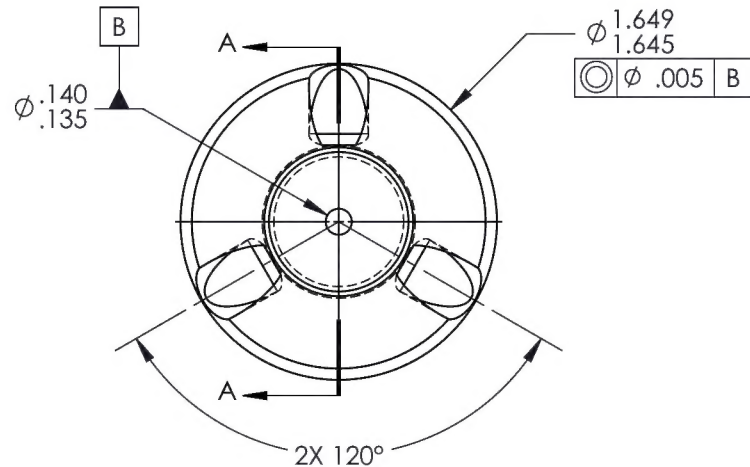
SHEET 2 OF 9

-1

ROLLER FIXTURE

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			APPROVED

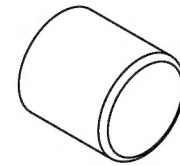
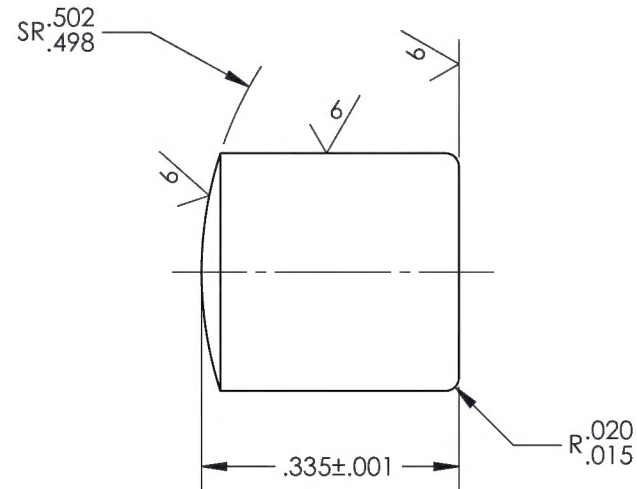
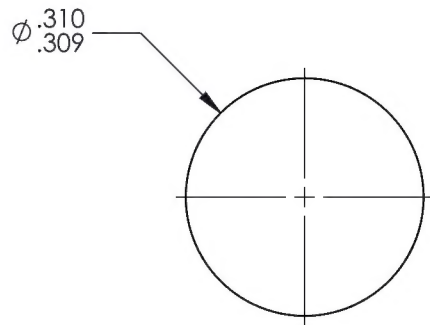


(-3)
RETAINER

DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-3	REV 1
MAT'L BRONZE TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm 5° .X \pm .1 SURFACES = 125 \sqrt	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 04/05/2017 CHECKED: SM 04/05/2017 OPPTS APPR: AA 04/05/2017 QA APPR: JL 04/05/2017 APPROVED: JAG 04/06/2017	
SCALE 1:1	DATE 4/5/2017
SHEET 3 OF 9	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

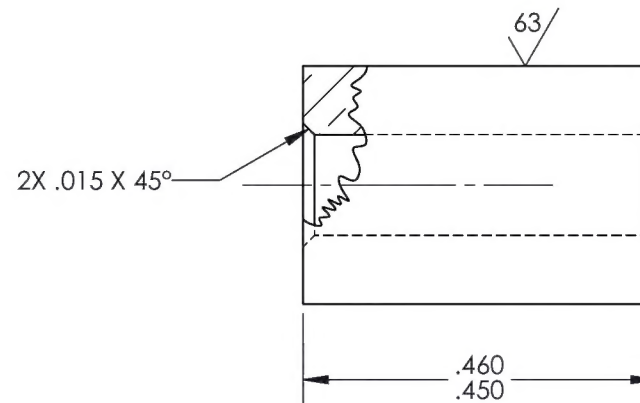
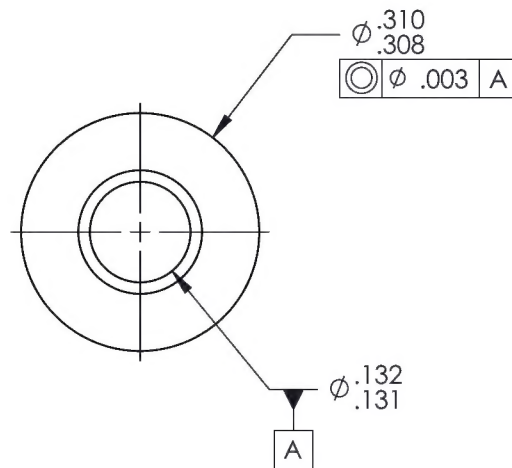
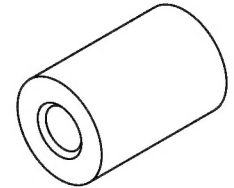


(-5)
ROLLER

DART AEROSPACE																									
TITLE DRILL PRESS SWAGING TOOL																									
DWG NO. RBST4241-5	REV 1																								
<table border="1"> <tr> <td>MAT'L STEEL</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT RC 55-60</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>DRAWN BY: DD 04/05/2017</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED: SM 04/05/2017</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR: AA 04/05/2017</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR: JL 04/05/2017</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED: JAG 04/06/2017</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>SCALE 4:1</td> <td>DATE 4/5/2017</td> </tr> <tr> <td colspan="2">SHEET 4 OF 9</td> </tr> </table>		MAT'L STEEL	UNLESS OTHERWISE SPECIFIED	HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/	DRAWN BY: DD 04/05/2017	1. BREAK ALL SHARP EDGES	CHECKED: SM 04/05/2017	.015 x 45° OR .015R	OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY	QA APPR: JL 04/05/2017	AFTER PLATING	APPROVED: JAG 04/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	SCALE 4:1	DATE 4/5/2017	SHEET 4 OF 9	
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED																								
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES																								
FINISH	.XXX ± .005 FRACTIONS ± 1/8																								
SPEC	.XX ± .01 ANGLES ± 5°																								
	.X ± .1 SURFACES = 125/																								
DRAWN BY: DD 04/05/2017	1. BREAK ALL SHARP EDGES																								
CHECKED: SM 04/05/2017	.015 x 45° OR .015R																								
OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY																								
QA APPR: JL 04/05/2017	AFTER PLATING																								
APPROVED: JAG 04/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																								
SCALE 4:1	DATE 4/5/2017																								
SHEET 4 OF 9																									

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NOTE:
BREAK ALL SHARP CORNERS .015 - .030.



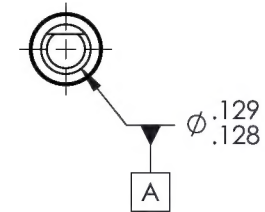
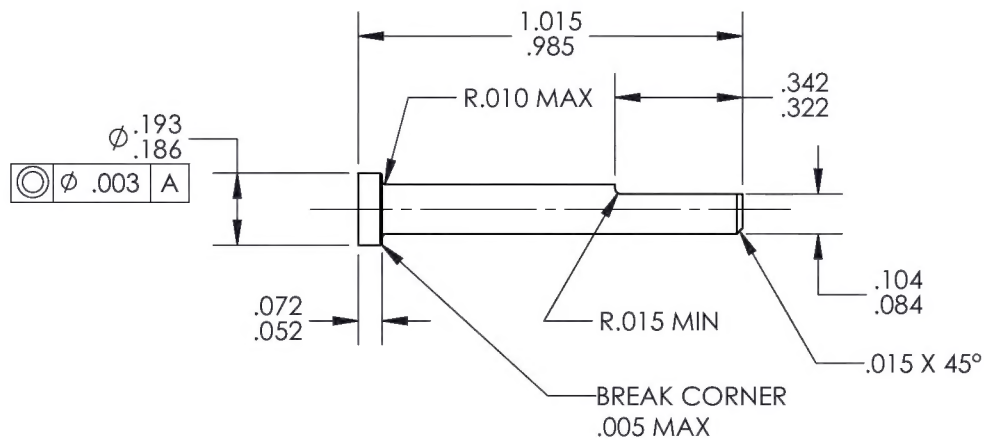
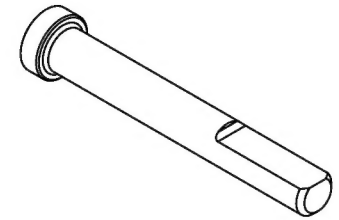
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DWG NO.		RBST4241-7	
REV		1	
MAT'L BRONZE		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX \pm .005 FRACTIONS \pm 1/8	
SPEC		.XX \pm .01 ANGLES \pm 5°	
DRAWN BY: DD 04/05/2017		.X \pm .1 SURFACES = 125	
CHECKED: SM 04/05/2017		1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 04/05/2017		.015 x 45° OR .015R	
QA APPR: JL 04/05/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 04/06/2017		AFTER PLATING	
SCALE		USED ON MODEL	
4:1		DATE 4/5/2017	
		SHEET 5 OF 9	

(-7)

GUIDE

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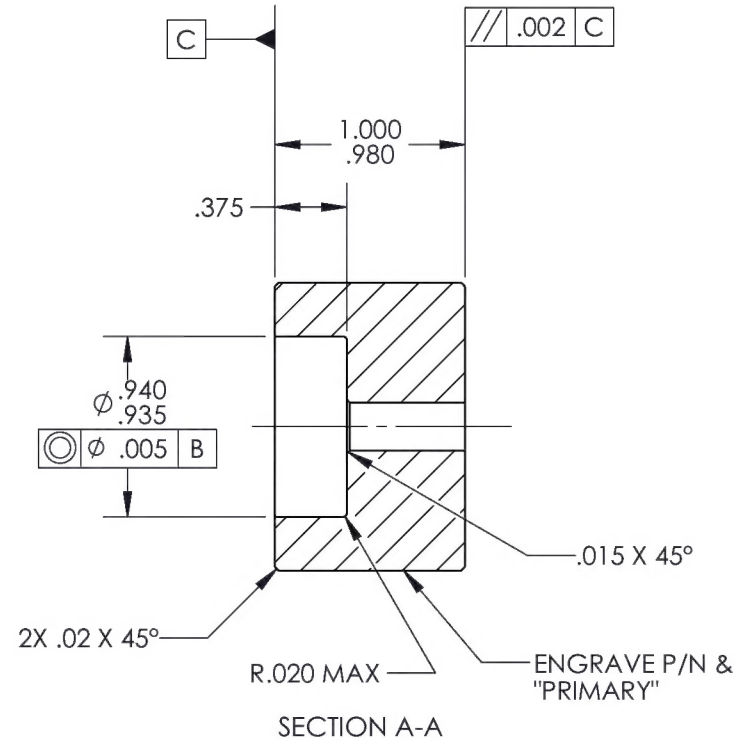
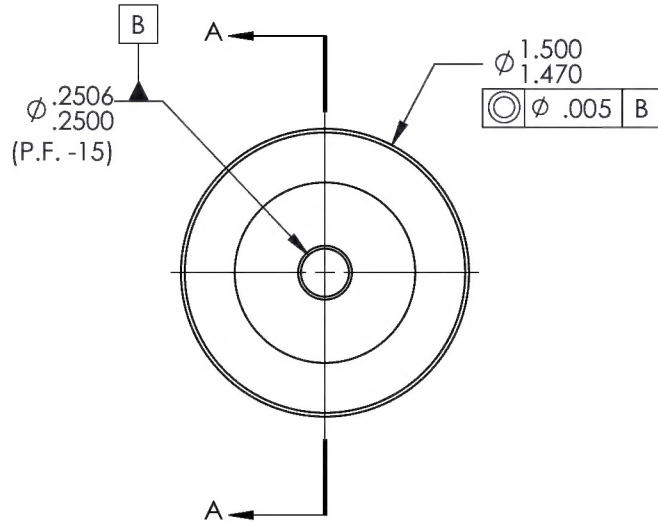
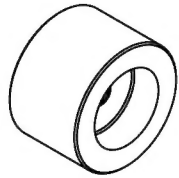
(-9)

PIN

DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-9	REV 1
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 04/05/2017	.X ± .1 SURFACES = 125°
CHECKED: SM 04/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/05/2017	.015 x 45° OR .015R
QA APPR: JL 04/05/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 04/06/2017	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
SCALE 2:1	DATE 4/5/2017
	SHEET 6 OF 9

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				APPROVED



NOTE:
BREAK ALL SHARP EDGES .015 - .030.

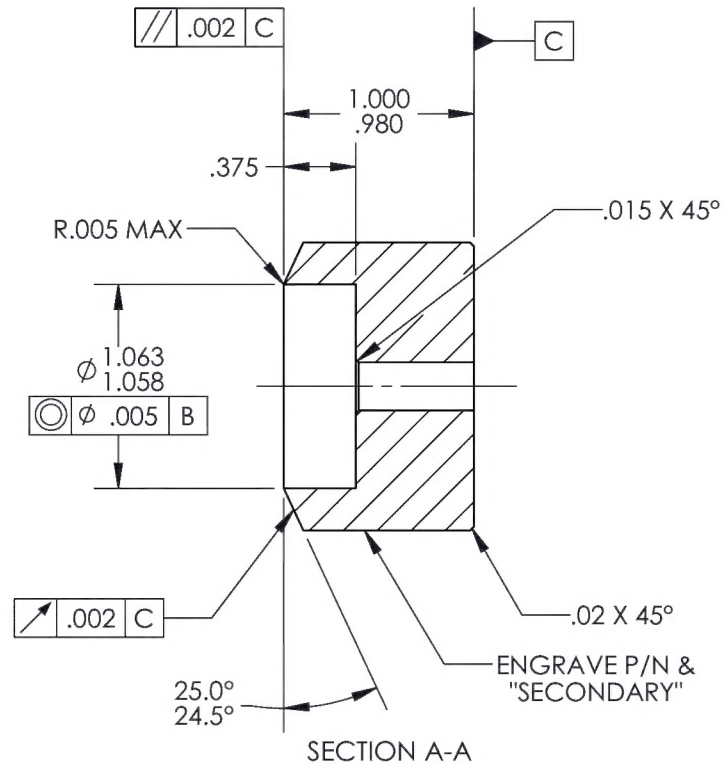
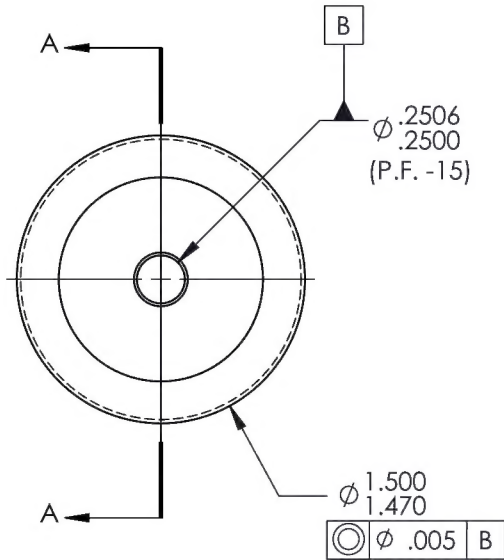
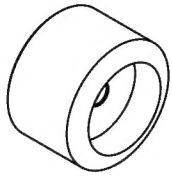
DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-11	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: DD 04/05/2017	.X \pm .1 SURFACES = 125
CHECKED: SM 04/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/05/2017	.015 x 45° OR .015R
QA APPR: JL 04/05/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 04/06/2017	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 1:1	DATE 4/5/2017
	SHEET 7 OF 9

(-11)

PRIMARY SEAT

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				APPROVED



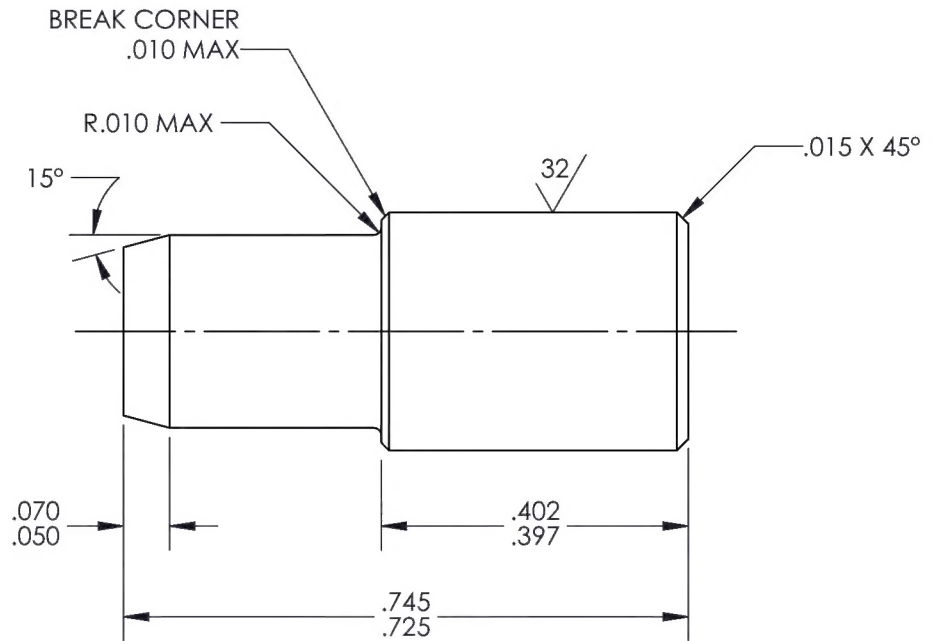
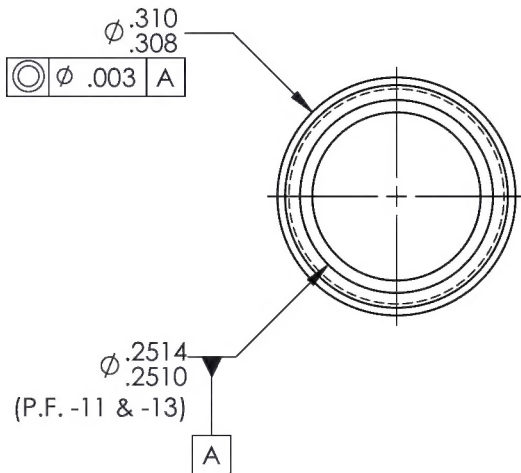
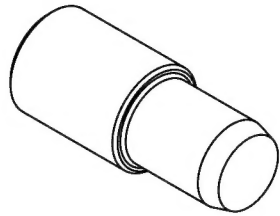
NOTE:
BREAK ALL SHARP CORNERS .015 - .030.

(13)
SECONDARY SEAT

DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-13	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: DD 04/05/2017	.X \pm .1 SURFACES = 125✓
CHECKED: SM 04/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/05/2017	.015 x 45° OR .015R
QA APPR: JL 04/05/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 04/06/2017	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 1:1	DATE 4/5/2017
	SHEET 8 OF 9

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				APPROVED



(-15)
 LOCATING PIN

TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-15	REV 1
MAT'L 1018/1020 CR HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 04/05/2017 CHECKED: SM 04/05/2017 OPPTS APPR: AA 04/05/2017 QA APPR: JL 04/05/2017 APPROVED: JAG 04/06/2017	
USED ON MODEL	
SCALE 4:1	DATE 4/5/2017
SHEET 9 OF 9	